

25
Work Order ID 51673-2

August 27, 2009 8:41:07 AM

split 2



Page 1

Item ID: D3405-041
Revision ID: B
Item Name: Lug Assembly

Start Date: 8/27/09 Start Qty: 24.00
Required Date: 9/11/09 Req'd Qty: 34.00

Reference:

Approvals:

Process Plan:

QC:

Date: 8-27

Date:

Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3405
Deburr if necessary

Dwg Rev: B

Prog Rev: B 2-

B 9-9-16

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 9-9-16

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

2) 8-27/09/17

conts
(x44) /

Work Order ID 51673

August 27, 2009 8:41:07 AM



Page 2

Item ID: D3405-041
Revision ID: B
Item Name: Lug Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 34.00



Required Date: 9/11/09 Req'd Qty: 34.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburri Form using DT8204 as per Dwg D3405

0.00

0.00

SB 09/09/21

44

✓

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2 Solder 127

counters
244

✓

150



Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 Identify as D3405-041

0.00

0.00

M107600

EL

9-10-13

X19

Work Order ID 51673

August 27, 2009 8:41:07 AM



Page 3

Item ID: D3405-041
Revision ID: B
Item Name: Lug Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 34.00
Required Date: 9/11/09 Req'd Qty: 34.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

QC 09.10.13

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

27 09/10/14

(19) P

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: *1:00pm* FINISH TIME: *4:00pm*
OVEN TEMPERATURE: *400°F*

M112260

27 09/10/14

(19) P

Work Order ID 51673

August 27, 2009 8:41:07 AM



Page 4

Item ID: D3405-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 8/27/09 Start Qty: 34.00

Required Date: 9/11/09 Req'd Qty: 34.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09/10/15 (19)

200

Identify as per dwg & Stock Location: 474

0.00



Packaging

Memo

0.00

Packaging

09/10/15 (24)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/15

mf
09-10-15

Picklist Print

August 27, 2009 8:41:06 AM

Work Order ID: 51673

Parent Item: D3405-041RevB

Parent Item Name: Lug Assembly

Comments:

Component Item ID/
Item Name

Replacement
Item ID

Mfg/
Purch

Bin
Item

Primary
Location

Last
Location

Route
Seq ID

Unit of
Measure

Qty on
Hand

Remaining
Qty To Pick

Qty
Issued

Date
Issued

Status

D3404-1RevC



GHW Lug

Manufactured No

Start Date: 8/27/09

Start Qty: 34.00

Required Date: 9/11/09

Required Qty: 34.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

33

45372

8

50471

25

Purchased

No

150

sf

63.6179

5.5116

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

63.61789789

111018

63.6178979

M304S11GA



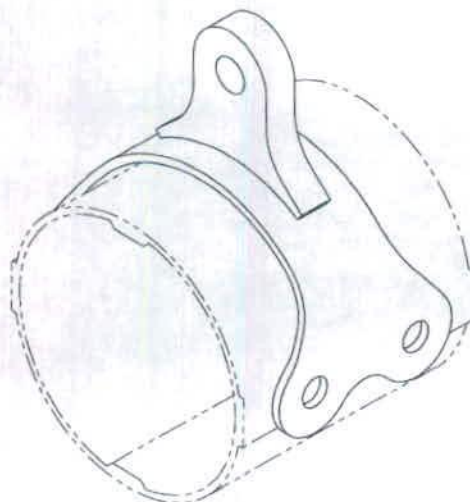
304/316 0.125 Sheet

EL 9-10-15

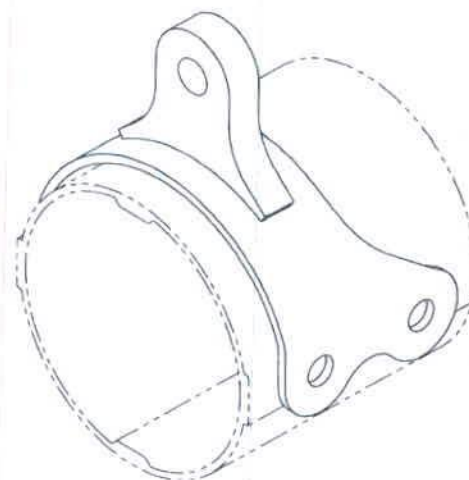
B9-9-16

111018

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

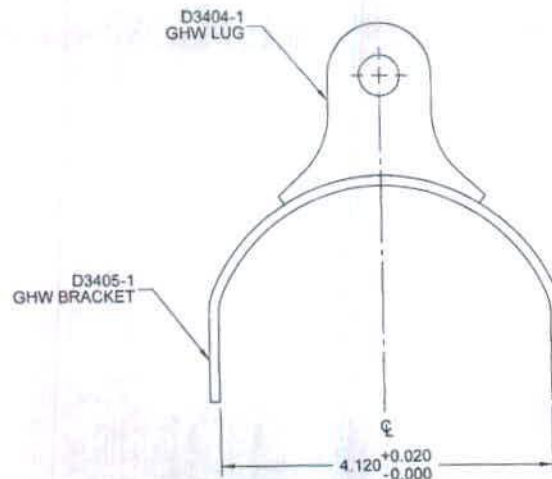
51673

RELEASED
08/12/18

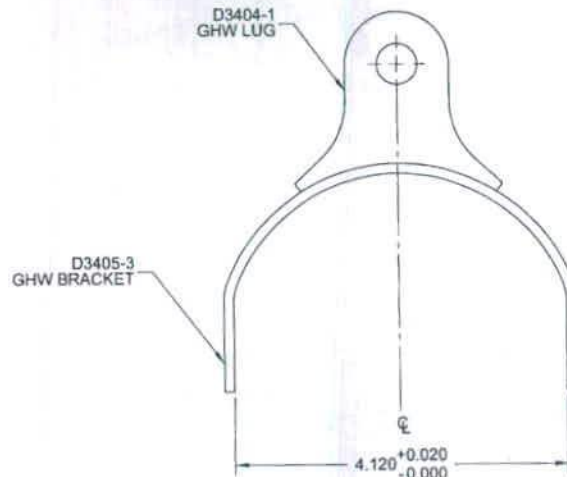
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

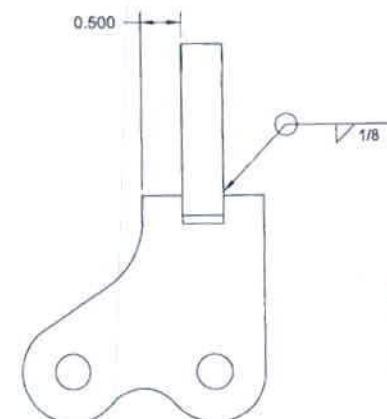
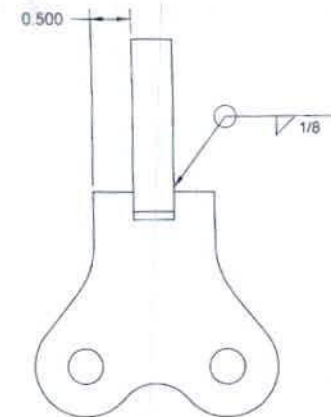
DESIGN	PH	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE AS 4.120 DIM WAS 4.100.		AJS	08.09.19
DRAWN	AJS	NEW ISSUE		PH	05.03.08
CHECKED		DESCRIPTION		BY	DATE
MFG. APPR.		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B	
APPROVED		DRAWING NO. D3405		SHEET 1 OF 4	
DE APPR.		TITLE GHW LUG ASSEMBLY		SCALE NTS	
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3405-041 LUG ASSEMBLY



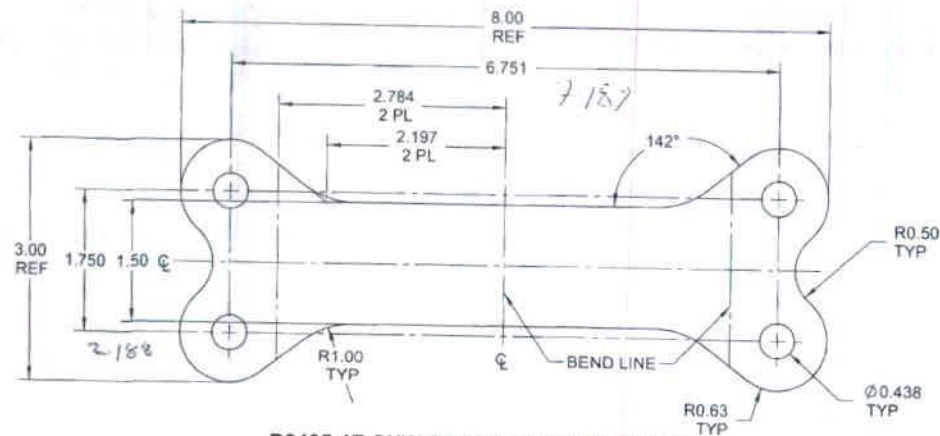
D3405-043 LUG ASSEMBLY



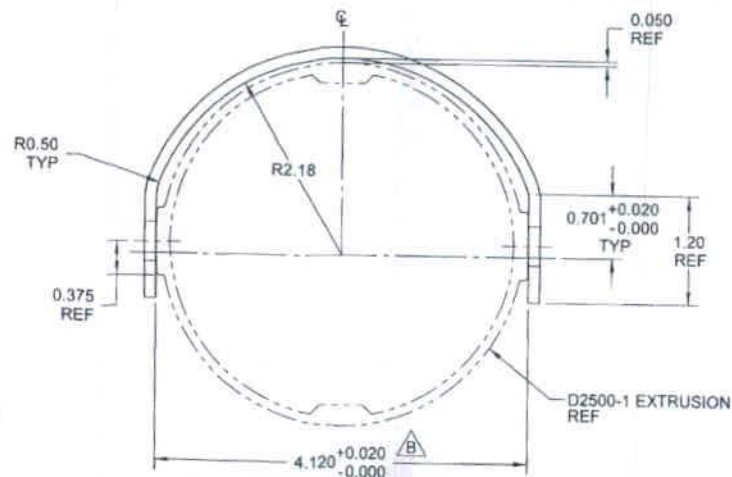
51673

RELEASED
06/12/18

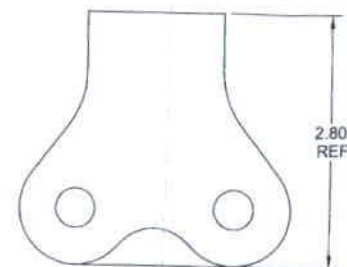
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ISSUED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

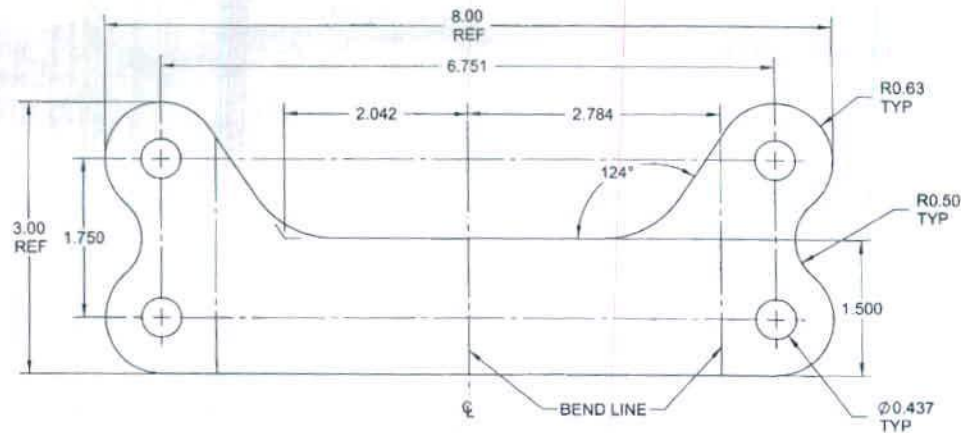
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

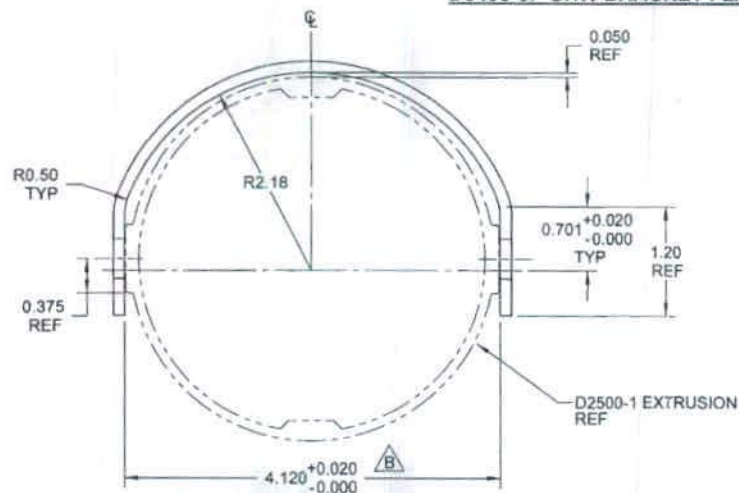
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF CONFIDENTIALITY THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08/09/19

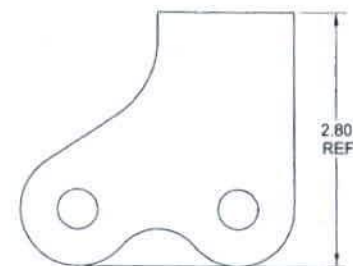
51673



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

51673

RELEASED
06/12/14 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

